

Date: Monday, 23/03/2009 9:53:36 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 46640		Part Number	: D2804042		
Estimate Number	: 10334		Drawing Number	: D2804 REV C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 23/03/2009		Drawing Revision	: C		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 03/04/2009		
Previous Run	: 46313		Qty:	6		
Written By	:		Um:	10		
Checked & Approved By	: <u>JUL 09.03.23</u>		Each			
Comment	: Est F 05.03.30 MS21043-3 was MS21042L3		KJ/JLM			
	Est Rev:G As per Rev C 06-11-08 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D28042	Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		STA 155 Bracket	
		Pick:	
	Qty Part Number	Description	Batch
1	D2804-2	Bracket	<u>B46315</u> (6)
2.0	D28052	Stop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Stop	<u>Epo9/04/17</u>
		Pick:	
	Qty Part Number	Description	Batch
1	D2805-2	Stop	<u>B46736</u>
3.0	D2809	Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Bushing	<u>Epo9/04/17</u>
		Pick:	
	Qty	Part Number	Description
1	D2809	Bushing	<u>B46438</u>
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1-Press D2805-2 into arm as per Dwg D2804	
		2-Press Fit D2809 as per Dwg D2804	
			<u>Epo9/04/17</u> (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		*					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 9:53:36 AM
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Drawing Name: BRACKET ASSEMBLY

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Part Number: D2804042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/17 76

6.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 M110 939

START TIME: 10:50

OVEN TEMPERATURE: 3200

FINISH TIME: 11:10

11:09-04-20

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-20

X6

8.0 AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C16A

Bolt

M111193

50

9.0 MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

9

Qty

Part Number

Description

Batch

2

MS21043-3

Nut

M111041

③

50

10.0 NAS1515H3

Washer



M109268 9/4/20

6x

Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

9

Qty

Part Number

Description

Batch

4 NAS1515H3

Washer

A/R

LPS-3

Corrosion Spray

M109929

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2804042

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

09/04/22 (6)

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/22 (X6)

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST150

09/04/22 (X6)

14.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF
09-04-22

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

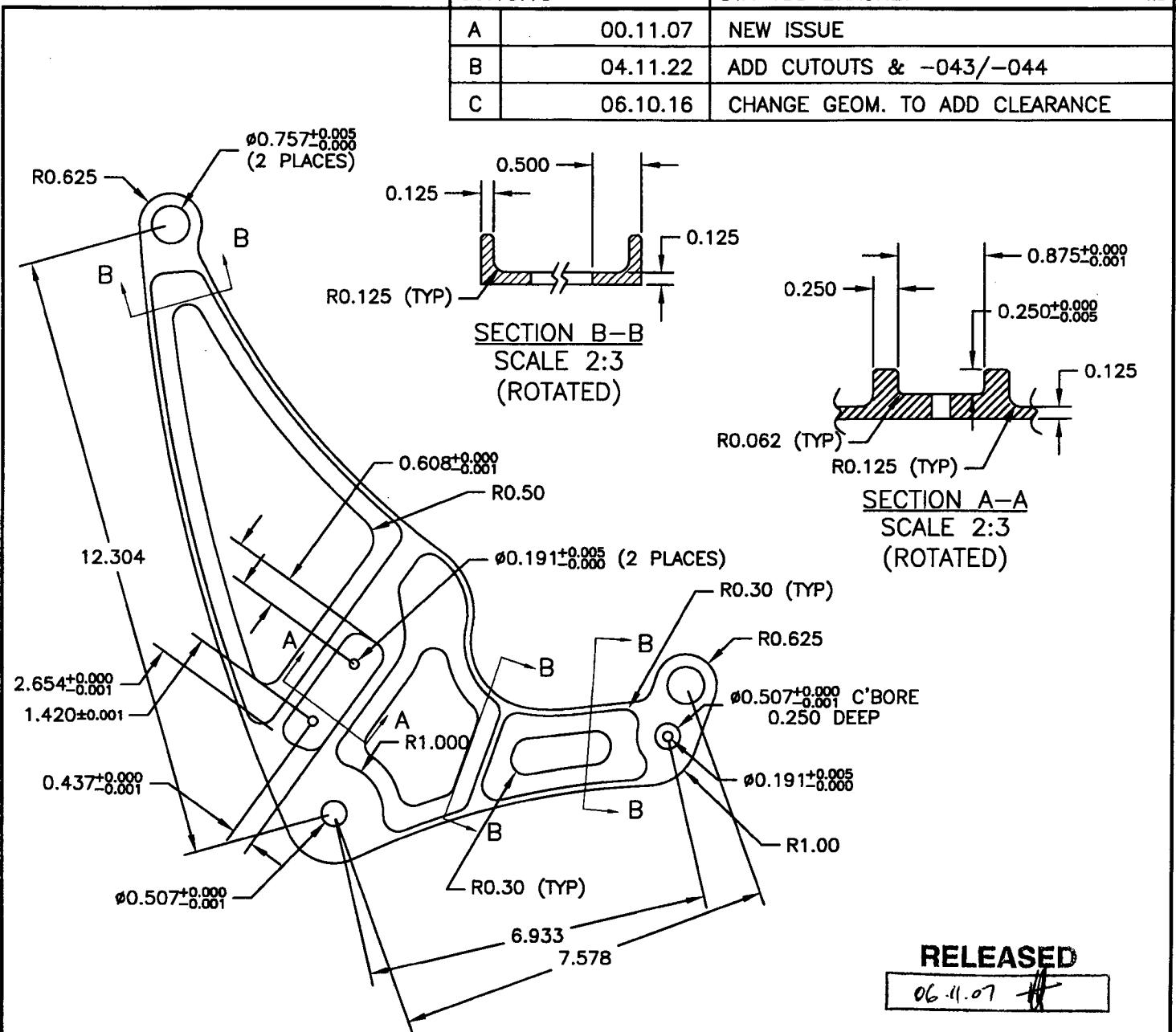
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CP	CP	
CHECKED	APPROVED	DRAWING NO. D2804
		REV. C
DATE		SHEET 1 OF 2
06.10.16		SCALE 1:3
A	00.11.07	TITLE STA 155 BRACKET
B	04.11.22	ADD CUTOUTS & -043/-044
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING

CONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

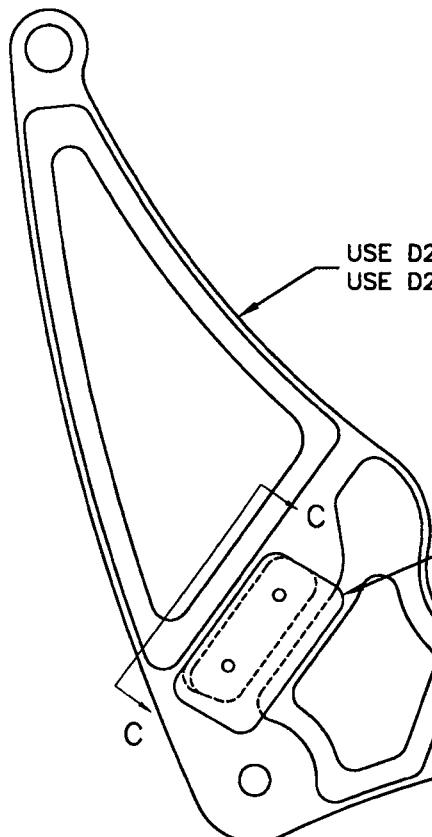
NO. 1010

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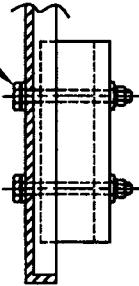
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21042-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



USE D2804-1 FOR D2804-041/-043
USE D2804-2 FOR D2804-042/-044

SECTION C-C
SCALE 1:3
(ROTATED)

USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
USE D2805-3 FOR D2804-043
USE D2805-4 FOR D2804-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *[initials]*

RELEASED

06.11.07

**D2804-041/-043 BRACKET ASS'Y (SHOWN)
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

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